

# Work Order ID 50581

July 16, 2009 8:25:20 AM

Page 1

Item ID: D3852-042

Revision ID: A

Item Name: Rib Assembly

Start Date: 07/17/2009 Start Qty: 2.00

Required Date: 07/22/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *MF*

Date: *09-07-16* Tooling:

QC:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440  
jig! 12- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as  
per dwg D3852 13- c/sink hole as per dwg! 14- remove identification  
markings! 15- deburr

*SAD 09-07-17 2*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*=> Sort 100 042 42 6*

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D3759-1 bushing as per dwg D3852 ✓ A/R ER316 S.S. Rod  
Batch: *M101213* 2- grind bushing weld flush as per dwg dwg  
D3852 3- deburr hole if necessary

*Cpl 09-07-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 50581**

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Page 2

Item ID: D3852-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly

Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.07.22 (2)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=&gt; S01/7/02

(042)

(2)

X

150

Identify as per dwg &amp; Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

PD 09.07.22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50581

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Page 3

Item ID: D3852-042

Accept



Setup Start



Revision ID: A

Item Name: Rib Assembly

Stop



Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/07/23 *[Signature]*  
mf 09-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 50581

Parent Item: D3852-042RevA

Parent Item Name: Rib Assembly

Comments:

Start Date: 07/17/2009

Required Date: 07/22/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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✓ D3166-3RevA1

Manufactured

No

100

Each

8.0000

0.3789



Basket Hoop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

8

48429

2

50033

6

0.3789

SAD 09-07-17

(Qty 2)

D3759-1RevA

Manufactured

No

100

Each

60.0000

2.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

24

48331

24

Main Warehouse

WA

36

50000

36

2 6/09-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

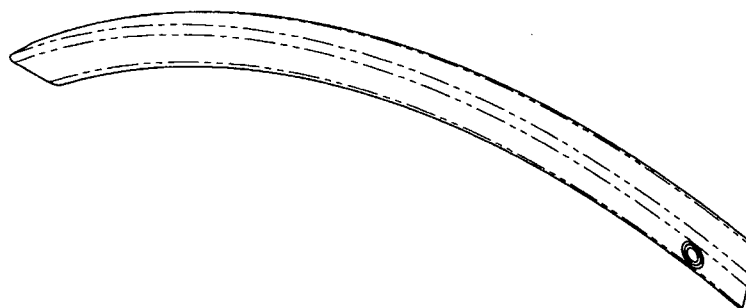
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

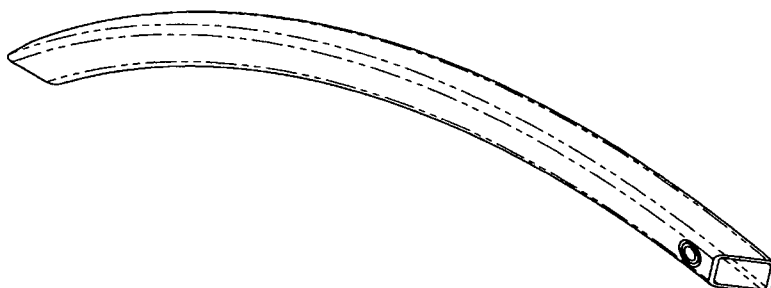
**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



**D3852-041 RIB ASSEMBLY**



**D3852-042 RIB ASSEMBLY**

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WITHOUT NOTICE  
WORK ORDER  
NO. 50581  
MF 09-07-16

RELEASE  
08/11/07 MF

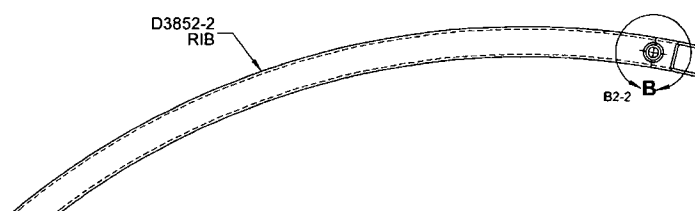
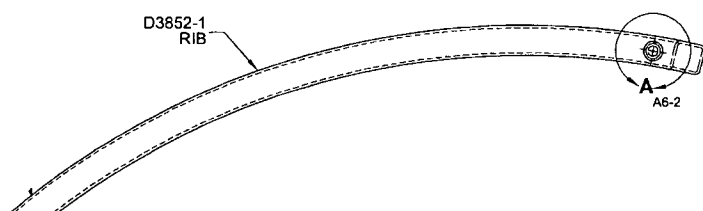
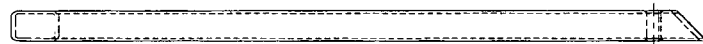
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.83 lbs EACH
  - 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

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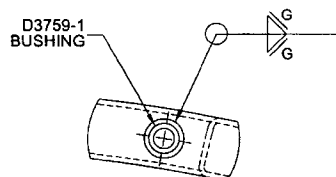
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REV. A  
SHEET 1 OF 3  
TITLE RIB ASSEMBLY  
SCALE NTS

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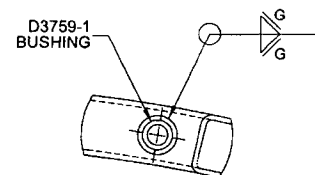


**D3852-041 RIB ASSEMBLY**

**D3852-042 RIB ASSEMBLY**



**DETAIL A**  
SCALE 2X C5-2

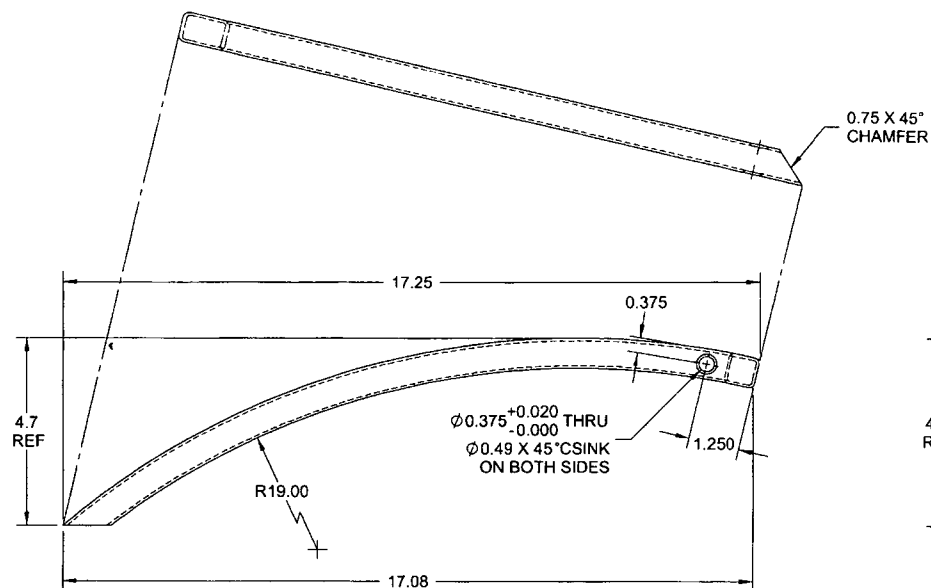


**DETAIL B**  
SCALE 2X C2-2

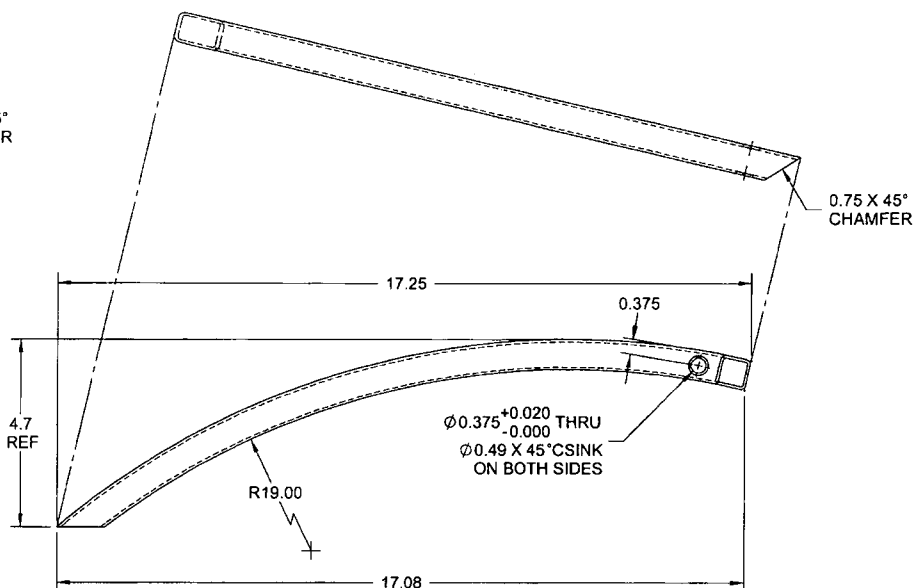
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**D3852-1 RIB**



**D3852-2 RIB**

- NOTES:**  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF. DART SPEC. M304TS0.750W0.065  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.82 lbs EACH

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